An IC Inclustries Company

Waukesha Foundry Division **Abex Corporation** 1300 Lincoln Avenue Waukesha, WI 53186 (414) 542-0741

May 7, 1984 Applicant ..... Check No. ... Amount Tes Calenny 4.7

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Date Check Rec'd

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U. S. Nuclear Regulatory Commission 799 Roosevelt Road Glen Ellyn. IL 60137

Attention: Material Licensing Section

Subject: License Amendment to License #48-13776-01

Gentlemen:

Enclosed are the results of the written and practical examinations by Daniel Soch, Ronald Wardinski and Dennis Grace. We are hereby requesting that Daniel Soch and Ronald Wardinski be changed from Assistant Radiographers to Radiographers, and Dennis Grace be added to the license as an Assistant Radiographer.

A check for \$40.00 to cover the amendment fee is enclosed. Thank you for your help in this matter.

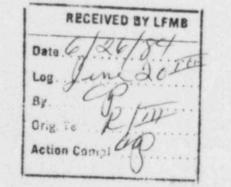
Sincerely.

ulhony

Anthony J. Baures Radiation Safety Officer

Enclosures:

8409260009 840831 NMS LIC30 48-13776-01 PD



RECEIVED JUN 1 4 1984 REGION III



PDR

Control No. 76951

## USNRC Requirements Written Examination for RADIOGRAPHER

- 1. The absorption of gamma rays from a given source when passing through matter depends on:
  - the atomic number, density, and thickness of the matter (A)
  - B., the Youngs modulus value of the matter
  - C. the Poisson's ratio value of the matter
  - D. the specific activity value of the source
- 2. The gamma ray intensity at one foot from a one curie source of radioactive cobalt-60 is:
  - A. B. 14.4 roentgens per hour
  - 1000 roentgens per hour
  - C. 20 roentgens per minute
  - 10.3 milliroentgens per second D.
- 3. The cobalt-60 used in non-destructive testing emit:
  - Α. alpha particles
  - neutrons Β.

and the

S que

- Ç gamma rays
- X-rays
- 4. The specific activity of an isotope depends on:
  - (A,) the time the material has been in the reactor
  - B. the atomic number of the material
  - C. the gamma ray flux to which it was exposed
  - the Youngs modulus value of the material D.
- What is the maximum level of radiation allowed at the storage head of the 5. Picker cyclops unit when in the shielded position?

2 R/hour 200 mR/hour

- 35 mR/day
- 50 mR/hour
- 6. The energy of gamma rays is expressed by which of the following units of measure:
  - Α. Curie
  - 8. Roentgen
  - Half-life
  - Kiloelectron volt (KeV) or million electron volt (MeV)
- 7. If one curie of iridium-192 produces a dose rate of 5900 mR per hour at one foot, how many mR will ten curies produce at the same distance?
  - 590 Α. Β. 590,000 59 D 59,000

Control No. 76951

- Cobalt-59 becomes cobalt-60 when it is placed in a nuclear reactor 8. where it captures:
  - an electron
  - a neutron
  - a proton
  - contamination
- 9. Approximately how long would it take for a 10 curie cobalt-60 source to decay to 2-1/2 curies?
  - Α. 5.3 days
  - Β.
  - 5.3 years 10.6 years
  - None of the above
- 10. Cobalt-60 emits gamma rays of:

- A. B. 1.17 and 1.33 MeV
- 0.66 MeV
- C. 1.09 and 1.29 MeV
- 1.36 and 2.75 MeV D.
- 11. For a particular radioisotope, source strength is proportional to which of the following?
  - Α. Mass of source
  - Β. Physical size
  - Atomic weight
  - (D.) Number of curies
- 12. Which of the following is true for a smaller isotope source of higher specific activity?
  - Α. Suffers less from self-absorption of its own gamma radiation
  - Β. Less geometric unsharpness in the radiograph
  - Allows shorter source-to-film distances C.
  - 0.) All of the above
- 13. Distance is an effective means of external radiation protection because:
  - air absorption reduces the radiation intensity
  - (B) radiation intensity varies inversely as the square of the distance
    - C. X-rays and gamma rays have a finite range
  - D. the wavelength of the photons is decreased by their interaction with matter
- 14. A radiation level of 100 mR/hr is noted at the perimeter of your posted high radiation area. This perimeter is 10 feet from the exposed source. Approx-imately how far away from the source should the radiation area signs be posted for the 2 mR/hr line.

 $\begin{array}{rcl} & \text{mR/hr line.} & \text{Control No. 76951} \\ & 40 \text{ feet } & 2mr/m = 100 \, \text{mr/h} \left(\frac{10}{r}\right)^2 & r^2 = 50 \left(10\right)^2 \\ & 100 \text{ feet } & \\ & 70 \text{ feet } & 2mr/m \cdot r^2 = \frac{100 \, \text{mr/h}}{2mr/m} \left(\frac{10}{r^2}\right)^2 & r^2 = 50 \times 100 \\ & 125 \text{ feet } & \frac{2mr/h}{2mr/m} \cdot r^2 = \frac{100 \, \text{mr/h}}{2mr/m} \left(\frac{10}{r^2}\right)^2 & r^2 & \sqrt{5000} \\ \end{array}$ B

- 15. With appropriate controls, the allowable radiation limits in unrestricted areas should not exceed:
  - 0.500 rem per calendar year Α.
  - 2 millirems in any one hour Β.
  - 100 millirems in seven consecutive days
  - all of the above
- A "leaking" source of radioactive material is considered a potentially 16. hazardous situation. At what removable activity level is a sealed radiography source, by regulation, considered to be leaking?
  - 0.0500 microcuries Α.
  - 0.5000 microcuries
  - 0.005 microcuries
  - 0.0005 microcuries
- Sources of radioactive material used for radiography are required by 17. regulation to be leak tested at intervals not to exceed:
  - 6 months
  - 3 months
  - 12 months
  - 24 months

18. X-ray photons differ from gamma photons of the same energy only in their:

- biological effect
- origin
- interaction
- wavelength
- 19. The half-life of a radioactive substance is equal to:
  - A. the reciprocal of the disintegration constant
  - the average lifetime of an atom in the substance
  - B the time required for one-half of the original atoms to disintegrate
  - the number of atoms present divided by the rate of decay
- Survey instruments used to monitor gamma radiation must be capable of 20. measuring radiation in the range of:
  - 0-2000 mR/hr. Α.
  - 2 mR/hr-10,000 mR/hr. Β.
  - 0-200 mR/hr.
  - 2 mR/hr-1000 mR/hr.
- 21. A radiation area refers to any area accessible to personnel in which radiation exists such that an individual could receive in any one hour a dose exceeding:
  - 2 millirems Α. Β. 100 millirems 5 millirems 500 millirems

Control No. 76951

- 22. Your radiation survey meter reads 10 mR/hour. How much of a dose will be delivered in one minute? .ille mile - in one hour? Iomalm - in 40 hours? Acometa
- You are working with a 75 curie cobalt-60 source. What is the dose rate 23. at 50 feet? 14 2 75 c = 1050 R/m D = 1050 (141 D = 42 R/m
- Using a cobalt-60 source you measure a dose rate at 5 mR/hour at 50 feet 24. from the source. You want to set up a boundary where the dose rate will be 2 mR/hour. What should the distance from the source to the boundary be? 2mr/2 = 5mr/2 (304)2 2mr/2 .r2 = smr/2 . (50)2 . + r2 = 2.5 (50)2 r= VL250 (79. feet
- +" = 6250 ¥= 79 \$+ 25. If you have a reliable pocket dosimeter you do not also have to have a film badge?

True False

You can request that the NRC conduct an inspection of your company if you 26. think there are safety problems?

> True False

Violations of NRC regulations can result in monetary fines and loss of 27. your company's license?

> A True False

- What is the calibration schedule for the survey meters being used with the 28. cobalt-60 source?
  - Α. monthly semi-annually
  - quarterly
  - yearly
- 29. Must dosimeters be calibrated per NRC regulation?

True False

- 30. The last day of the shipping month finds both survey meters inoperable and only a single exposure is needed to complete a casting that is absolutely needed. What course of action is acceptable to resolve the situation
  - receive permission from the Vice-President works manager to procede Α.
  - take the exposure being especially careful
  - C. shut the facility down
  - consult with the quality assurance manager and proceed D.

31. Describe how the unit will be tested for a power failure condition.

a Witch off power on digita timer

32. Describe the method used to test the door interlocks leading to the

cobalt-60 room. NFxpose the source, 2) with survey meter in hand, using Key to cotoroom open the door, gamma alarm should sound, the source should return to the stored preition (observe - red helt are around to the source should return

33. Is it the responsibility of the radiographer that all signs and labels are in their proper position?

| Ø  | Tru | le |
|----|-----|----|
| В. | Fal | se |

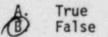
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in the second

- 34. Which of the following dosimeter ranges is acceptable for industrial radiography using isotopes?
  - A. 0 2C0 R B. 0 - 5 mR C. 0 - 200 mR D. 1 - 10 R
- 35. On what form will the record of the final shut down survey be recorded on?
  - A. Source Order Form 445
  - B. Quality Inventory Record 447
  - C. NRC Form #3
  - (D) Source Utilization and Survey Log 448
- 36. If a survey meter is out of calibration by two days and a "hot" job comes in for a single exposure in the cobalt-60 room, it is acceptable to carefully take the one exposure?

| Α. | True  |
|----|-------|
| B  | False |

37. Per the requirements of the operating and emergency procedure may isotope radiography continue with people working on the roof over head?



38. Describe the method used to secure the cobalt-60 area when a roofing contractor is working on the roof over the cobalt-60 cell.

Company maintenance supervisor shall arrange for complete securing of freili RS.O Shall secure oil sources (Locked) have keys on his person

- 39. Who is responsible for the quarterly maintenance inspection?
  - Maintenance Superin

Will Notify R.S.O.

B. radiographer

Α.

- C. maintenance superintendant
- (D) radiation safety officer

maintenance crew

WREn Workis comple

RSO Will inform

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In order to recently

area, entire procedure was

- 40. You have been working as a radiographer for several years and due to production requirements an assistant radiographer is assigned to you. Which of the following statements is true?
  - A. the person may work in the cobalt-60 area as long as they have a calibrated survey meter
  - B. assistant radiographers may not work in the cobalt-60 area
  - C assistant radiographers can only work in the cobalt-60 area under the personal supervision of a radiographer
  - D. if the person has worked in X-ray they may work in the cobalt-60 area
- 41. Which of the following situations contributes most to overexposure accidents during isotope radiography?
  - A. no dosimeter was used
  - B) inproper or no survey taken
  - C. hot weather
  - D. sudden disintergration of the source
- 42. Describe the method used to survey the Picker Cyclops unit.

The Survey meter is placed Immediately under the head the reading is noted the meter is placed on Both sides of the head the survey meter

43. How often must the leak test be conducted?

- A. monthly
- B. periodically
- C. semi-annually
- D. when the source is changed
- 44. When a cobalt-60 exposure has been set up and the exposure started, what information should be entered in the source utilization log form 448?

Sho stexposure date location Present well Frequer Rediction Rudiographer Noter

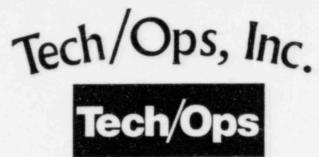
- 45. Does the radiographer have the authority to shut down the cobalt-60 area if he suspects a safety problem?
  - B. False
- 46. If during the course of making a set up the gamma alarm red light comes on, what should you do?
  - A. complete the set up
  - B. go over and hit the gamma alarm on the side, something must be stuck
    - disregard it
  - D. leave cell immediately and evaluate the situation from outside the cell
- 47. Per the operating and emergency procedure manual, how many dosimeters are to be worn?  $+\omega h$

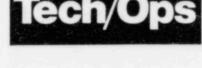
- 48. The Picker Cyclops will never be operated at a distance closer than <u>48.</u> from any wall.
- 49. What information must be on the survey meter before using it?
  A) Date of Collector
  b) Signature of Collector reperson
- 50. If a survey meter is dropped what should be done with it?

1.1. 1.1. 1.1. retured to Control room tag inoperable and exchanged for another and shall not be used until recalibrated

Non performed the daily inspection procedure and exposure procedure. The sheeked calibration of survey meter. I asked, if he droped the survey meter what would be do? He replied he would get another meter from the office and if one was not availiable he would discontinue aperations. Ron passed the practical yam.

a. Boures





## hereby certifies

Ronald N. Wardinski

has successfully completed the course: "Radiation Safety Aspects of Isotope Radiography"

ATTESTED: 17 September 1982

1190.3311

1185.338

JOSEPH RING Instructor

UFATIL

Control

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JOHN J. MUNRO, 'II Technical Director

3

MAN N

11/2310

CLARKE Ph.D. Founder & Director

Harris

Dennis Grace 5/3/84

## WRITTEN EXAMINATION ' for MANUAL OF OPERATING and EMERGENCY PROCEDURES FOR INDUSTRIAL RADIOGRAPHY

- 1. If a survey meter is accidentally dropped, what should be done with it?
- Under what condition may a radiographer or assistant radiographer work without a dosimeter?
- 3. The exposure device will never be operated at a distance closer than from any wall.
- 4. Before maintenance personnel are admitted to radiation areas, what procedure is to be followed?
- 5. What items are to be checked at the beginning of each days work and recorded on the appropriate form?
- 6. How many MR will a dosimeter record?
- 7. If the exposure device should malfunction, may the radiographer repair the device?
- 8. What frequency is leak testing done?
- 9. What information must appear on a survey meter before using it?
- 10. What level of radiation is acceptable 6 inches from any exterior surface of the exposure device?
- 11. What label shall appear on each device containing sealed byproduct material?
- 12. What sealed sources is Waukesha Foundry Co. licensed to use?
- 13. What is to be done when a survey meter becomes inoperable?
- 14. How many dosimeters must a radiographer wear during radiographic operations?
- 15. When the "Daily Inspection and Maintenance" procedure is being conducted, how is power failure simulated?
- 16. What are the duties and responsibilities of the radiographer?
- 17. Who does the radiographer directly report to?
- 18. What procedure must be followed at the end of radiographic operations each day?
- 19. Must a radiation survey be taken before every radiographic exposure?

20. Where is the radiographic restricted area located?

- 21. The keys to the Picker Cyclops are under whose direct control?
- 22. How often will dosimeters be checked by the radiographer during radiographic operations?
- 23. Does the replacement of bateries in a survey meter require recalibration?
- 24. How many rem per year are allowed for a whole body dose?
- 25. How often are the films for the film badge monitering system to be changed?

Minimum passing grade 80%

Answers on separate paper.

Dennis Grace explained how he would replace a battery if the meter should need it. He went through the daily maintenance procedure. Also he went through a radiographic exposure and followed all the points for survey and documentation. Passed Priactical

a. Boures

R.S. O.

5/3/84

Written Exam - Operating & Emergency procedures 1. If a survey meter is dropped you should stop working, take it to the control room and mark on it that it was dropped. It must be sent for recalibration.

- 2. The radiographer + his assistant may never work without dosimeters.
- 3. The exposure device will never be operated at a distance closer than 4 Feet from any wall
- 4. Before maintenance personnel are admitted: supervisor of Maintenance dpt. most arrange for complete securing of the facilities for reguired time. R.S.O. most check that all sources are safe and locked. He must keep interlock and source lock keys. Give an ok to maintenance, maintenance must check back with him when complete. They may not re-enter again without follows the procedure again.
- 5. Radiation Level, Shutter time, Door Interlock, Warning Lights, Emergency Shutter, Rower Failure, Signs + Labels must be checked at the beginning of each days work.
- 6. A dosimeter can record up to 200 mm.
- 7. The radiographer may not repair the device.
- 8. Leak tests must be performed every 6 months.
- 9. Label on survey meter > date of calibration, Signature of calibrating person, date of next required calibration.
- 10. Exposure devices may not have a radiation level in excess of 60 mr per hour at 6" from the exterior.
- 11. Each device must have a label with the radiation caution symbol, The words "caution radioactive material" and the type and quantity of material.

5/3/84

- 12. Waukesha Foundry Co. 15 licensed For Cobo
- 13. If a survey meter becomes inoperable, work is to cease until meter has been serviced a recalibrated or replaced by another.
- 14. A radiographer must wear Z dosimeters,
- 15. With the unit on, shut off the main power supply, the unit should return to the off position.
- 16. Duties of Radiographer: Compliance with N.R.C. Regulations and procedure in the manual, for him or people under his supervision. Enforcement of all personnel safter rules, Availability, use, and good working condition of all personnel monitering equipment. Recording dosimeter readings, reporting of radiological health emergencys to R.S.O. Recording results of daily inspection + maintenance procedure on form 451
- 17. Radiographer reports directly to the Radiation Saftey Officer 18. At the end of each day the head of the unit will be surveyed and readings noted on Source Utilization Form 448. The door to the exposure room will be locked.
- 19. Yes, a survey must be taken before every exposure.
- 20. Restricted area is where a person could recieve an exposure in excess of Zmr in any one hour. In our area it is at the door entrance to the room.
- 21. The keys to the Picker Cyclops are under the R.S.O.s control.
- 22. Posimeters should be checked every few hours during operation.
- 23 No replacing batterys in a survey meter does not require recalibra 24 5 rem per year for a whole body dose.
- 25 Film is changed every month in film badges

Conirol No. 76951

mer. mount mersi atton aller south allons 1111 an san Hi ton ann Tech/Ops, Inc. Tech/Ops hereby certifies DENNIS GRACE has successfully completed the course: "Radiation Safety Aspects of Isotope Radiography" April 13, 1984 ATTESTED: JOSEPH RING JOHN MUNRO III ERIC T. CLARKE, Ph.D. Instructor Technical Director Founder & Director and active and and and and and AT HE SAL HUTHIN STRUCK ROTE BEEN 101111 E a SITANIL MAN ITANU MILEANIN MICANIN Inall HEAR 118.311

Control No.

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86/ Dan Soch 6/6/84

USNRC Requirements Written Examination for RADIOGRAPHER

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and the

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- ) gamma rays
- . X-rays

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  - A. 2 R/hour
  - B 200 mR/hour
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  - A. Curie
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40 feet 100 feet 70 feet 125 feet

With appropriate controls, the allowable radiation limits in unrestricted 15. areas should not exceed:



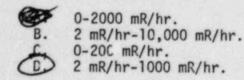
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- 0.500 rem per calendar year
- 2 millirems in any one hour

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all of the above

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21. A radiation area refers to any area accessible to personnel in which radiation exists such that an individual could receive in any one hour a dose exceeding:

| Α. | 2   | millirems |
|----|-----|-----------|
| Β. | 100 | millirems |
| 0  | 5   | millirems |
| D. | 500 | millirems |

Control No. 76951

22. Your radiation survey meter reads 10 mR/hour. How much of a dose will be delivered in one minute? . 1666mR Dose = 10mR/hr × to hr
 in one hour? 10mR
 in 40 hours? 400mR

- 4 -

23. You are working with a 75 curie cobalt-60 source. What is the dose rate at 50 feet?  $432 \text{ R/m} = D = O_0(\frac{1}{29}) D = 75 \text{ Ci} \times \frac{14.4 \text{ R/m}}{16} \times \frac{14.4 \text{ R/m}}{16}$ 

= 1080 ( 1 - ) R/h-

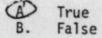
= ,432 R/h-

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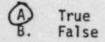
True False

411.

26. You can request that the NRC conduct an inspection of your company if you think there are safety problems?

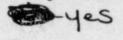


27. Violations of NRC regulations can result in monetary fines and loss of your company's license?



- 28. What is the calibration schedule for the survey meters being used with the cobalt-60 source?
  - A. monthly
  - B. semi-annually
  - c) quarterly
  - D. yearly
- 29. Must dosimeters be calibrated per NRC regulation?

True False



- 30. The last day of the shipping month finds both survey meters inoperable and only a single exposure is needed to complete a casting that is absolutely needed. What course of action is acceptable to resolve the situation
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  - B. take the exposure being especially careful
  - G shut the facility down
    - D. consult with the quality assurance manager and proceed

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|---|------|
| Surn unit on Turn main swith on control panel of<br>the source should automatically go to the of closed po                            | R.   |
| The source should automatically go to the of closed of  | U.T. |
| streen light on paral abould be on streen light on, The   | un   |
| best the method used to test the door interlocks leading to the   |      |
| webalt-60 room. and to see iff red light are place  | ing  |
| Open door to yoon Unit should go Ty closed position   | . 0  |
| Open door to room Unit should on To closed position<br>33. Is it the responsibility of the radiographer that all signs and labels are |      |
| in their proper position?   |      |
|   |      |

- 5 -

- True Β.
- False
- 34. Which of the following dosimeter ranges is acceptable for industrial radiography using isotopes?

Р<sub>В</sub> Рж.,

- 1000 年 - 1000 - 10

- 0 200 R Α. 0 - 5 mR0 - 200 mR 1 - 10 R
- On what form will the record of the final shut down survey be recorded on? 35.
  - Α. Source Order Form 445
  - Β. Quality Inventory Record 447
  - NRC Form #3
  - (0) Source Utilization and Survey Log 448
- If a survey meter is out of calibration by two days and a "hot" job comes in 36. for a single exposure in the cobalt-60 room, it is acceptable to carefully take the one exposure? No
  - Α. True 3 False
- 37. Per the requirements of the operating and emergency procedure may isotope radiography continue with people working on the roof over head? No

True False

Describe the method used to secure the cobalt-60 area when a roofing contractor 38. is working on the roof over the cobalt-60 cell.

- sacurency or gro or re RSO AT. diad to Son Son plating is responsible for the quarterly daintenance inspection? Are Who

- maintenance crew Α.
- Β. radiographer
- maintenance superintendant С.
- 0 radiation safety officer

40. You have been working as a radiographer for several years and due to production requirements an assistant radiographer is assigned to you. Which of the following statements is true?



. the person may work in the cobalt-60 area as long as they have a calibrated survey meter

assistant radiographers may not work in the cobalt-60 area

- assistant radiographers can only work in the cobalt-60 area under the personal supervision of a radiographer
- D. if the person has worked in X-ray they may work in the cobalt-60 area
- 41. Which of the following situations contributes most to overexposure accidents during isotope radiography?
  - A. no dosimeter was used
  - B inproper or no survey taken
  - C. hot weather
  - D. sudden disintergration of the source

42. Describe the method used to survey the Picker Cyclops unit. approach with watching survey meter. But meter right with to the collimator moting reading it should be consistent to the norm, survey around head. 43. How often must the leak test be conducted?

- A. monthly
- B. periodically
- Semi-annually
- D. when the source is changed

44. When a cobalt-60 exposure has been set up and the exposure started, what sind number, done, location, present Col. activity, imposure times padiation level outside closed door, radiographing mome or initiale, what view you are abouting.

45. Does the radiographer have the authority to shut down the cobalt-60 area if he suspects a safety problem?

True False

- 46. If during the course of making a set up the gamma alarm red light comes on, what should you do?
  - A. complete the set up
  - B. go over and hit the gamma alarm on the side, something must be stuck  $\mathcal{L}$  disregard it
  - 6
- leave cell immediatel, and evaluate the situation from outside the cell
- 47. Per the operating and emergency procedure manual, how many dosimeters are to be worn?

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- 48. The Picker Cyclops will never be operated at a distance closer than from any wall.
- 49. What information must be on the survey meter before using it? a - and of the calibration 50. If a survey meter is dropped what should be done with it?

1 1 1

a the

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Returned an clearly marked to control reven and exchanged for another and litre beau and ton Ilade and recolibrated.

Dan went through the daily inspection procedure and exposure procedure. He surveyed properly and tested the points of the inspection procedure. Passed the practical exan inspection procedure. a. Baures Radiation Safety Officer

Centrol No. 76951-

